

Date: Thursday, 9/20/2007 3:26:45 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR LH	<b>ENGINEERING APPROVAL</b>  <i>UNDER REVIEW</i> <i>UE 07.10.25.</i>
Job Number : 34739	Part Number : D32801	
Estimate Number : 11226	Drawing Number : D3280 REV B	
P.O. Number :	Project Number : N/A	
This Issue : 9/20/2007 S.O. No. :	Drawing Revision : B	
Prsht Rev. : NC	Material :	
First Issue : 1/1 Type : THERMOFORMING	Due Date : 9/27/2007	
Previous Run : 34620	Qty: 5 Um: Each	
Written By : <i>[Signature]</i>		
Checked & Approved By : <i>[Signature]</i>		
Comment : Est Rev:A 04.07.01 New issue KJ/JLM Est RevB 07.09.12 Thermoform in house DL		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F6002 701	lexan black
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Comment: Qty.: 4.3600 sf(s)/Unit Total : 21.8000 sf(s)  
lexan black .125"

Material Batch # 105235 x2 07.10.10 DL PTO  
105952 x6 07.10.25 DL

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

07.10.10 DL

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

x2 07.10.10 DL

Dwg. Rev. B  
Folio Rev. B

x6 07.10.25 DL

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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DL  
07.10.25

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.10.25 DL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3280-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 34739		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.10	3	2 Parts NOT FORMED SCRAPPED R.C. Parts were not formed enough. Heat.	<i>[Signature]</i> QS/10/2	<del>SCRAP 2 PARTS.</del> Reple and data, Scrap parts	07.10.25 WU	<i>[Signature]</i> 07/10/25	<i>[Signature]</i> QS/10/2	<i>[Signature]</i> 07/10/25

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR LH

Job Number: 34739

Part Number: D32801

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



P-TO

Comment: HAND FINISHING THERMOFORMING

07.10.25 dk.

1) Trim to Finished Dimensions

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

07.10.25 dk.

2) Check dimensions to ensure conformity to drawing tolerances.

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15 07/10/25 (76)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ENGINEERING  
APPROVAL  
07.10.25

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.31

Job Completion



07.10.31

Lucas (6x) AS 07/10/30

Signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3280-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/18/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>34739</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.25	5.0	18.2 is 18.4 12.18 is 12.13	LE 07.10.25 QSI 042	Acceptable	LE 07.10.25	S 2/10/05	LE 07.10.25 QSI 042	S 2/10/05

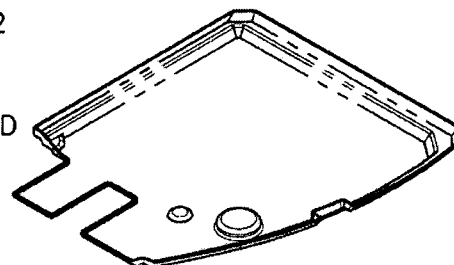
NOTE: Date & initial all entries



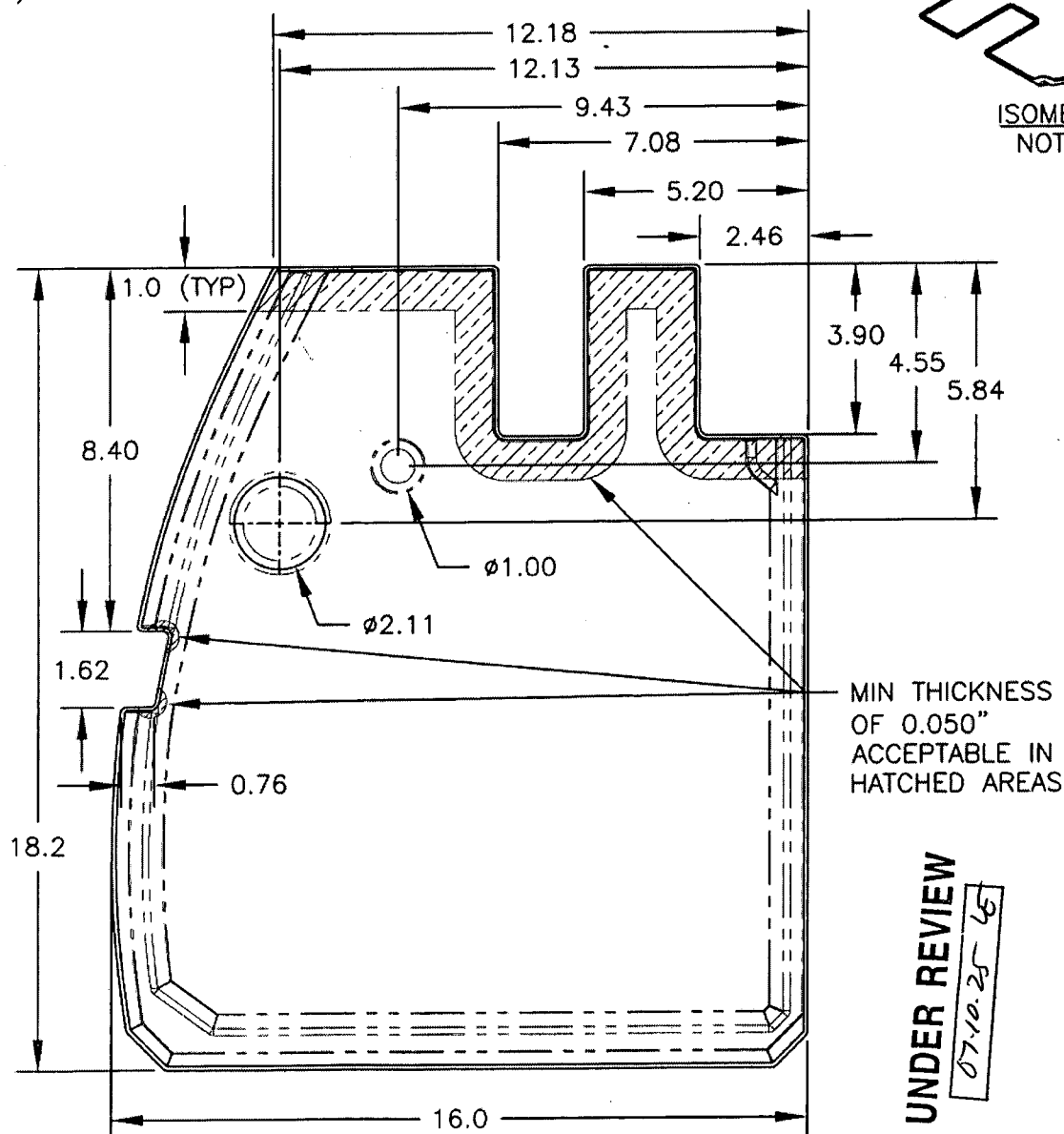
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3280	REV. B SHEET 1 OF 2
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:4
A	04.04.05	NEW ISSUE	
B	05.11.25	NOW LEXAN, DIMS AS MANUFACTURED	

### D3280-1 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-1T1, TRIM USING D3280-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN



ISOMETRIC DETAIL  
NOT TO SCALE



UNDER REVIEW  
07.10.25-65

RELEASED  
08.12.01

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WITHOUT NOTICE  
WORK ORDER  
NO. 34739

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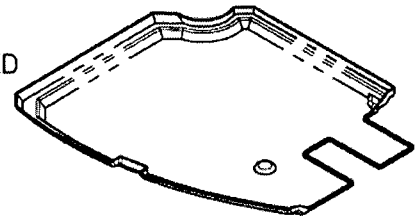
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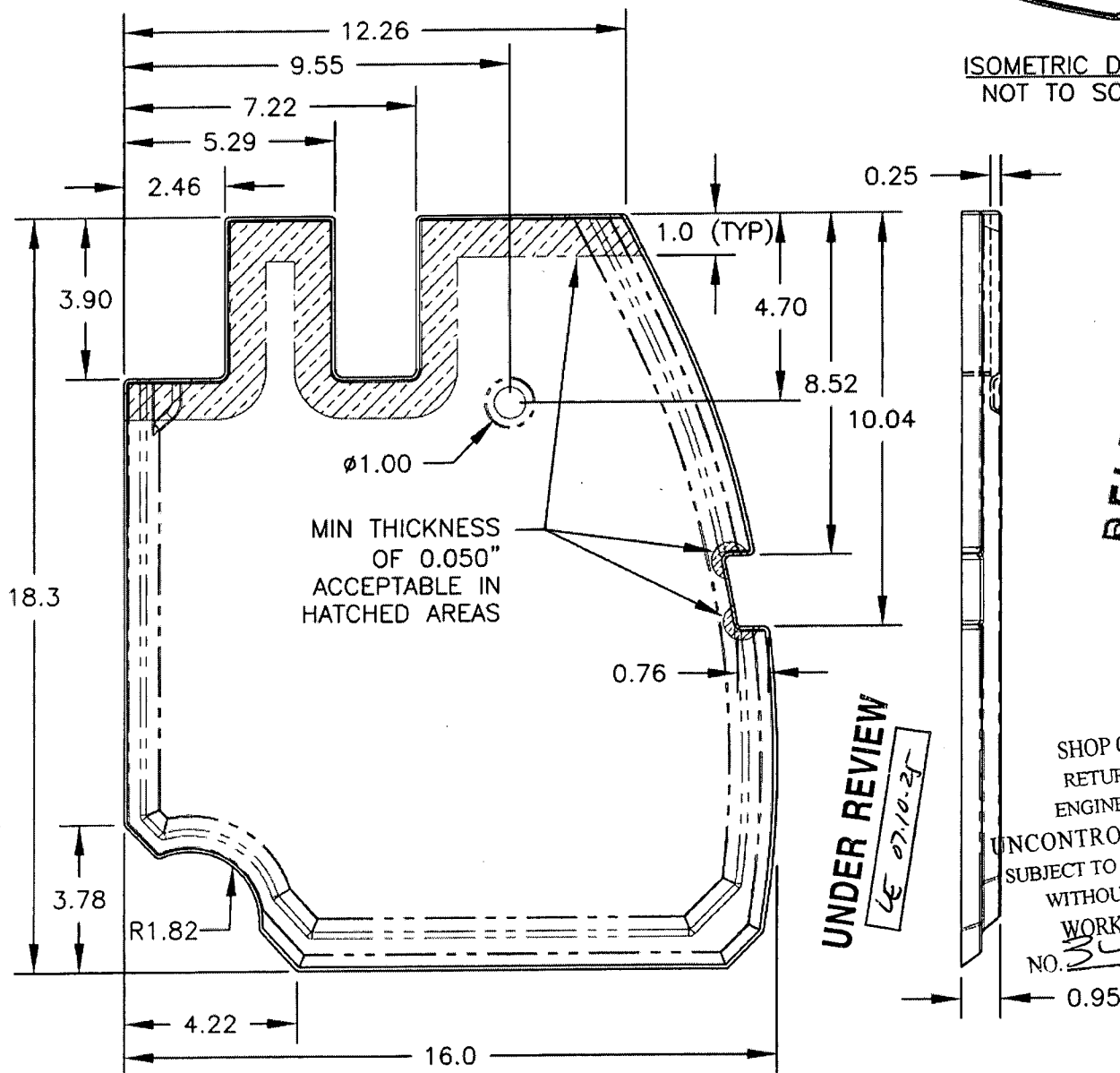
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3280	REV. B SHEET 2 OF 2
DATE 05.11.25		TITLE FLOOR PROTECTION	SCALE 1:4

### D3280-3 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-3T1, TRIM USING D3280-3T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080 EXCEPT AS SHOWN



ISOMETRIC DETAIL  
NOT TO SCALE



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05/12/01

UNDER REVIEW  
LE 07/10/25

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DART AEROSPACE LTD		WORK ORDER: 334739
Description: R22 Floor Protector LH		Part Number: D3280-1
Inspection Dwg: D3280	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	Wk
Acceptable shape definition	Wk
Acceptable texture retention	Wk
Free of visual flaws (bumps, cracks, voids, etc.	Wk

(Step 6) Trimming  
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3280 Rev. B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.2	.1	18.375			TAPE	ACCEPTABLE LE 07.10.25
16.0	.1	16.1	✓		TAPE	
12.18	.030	12.125			TAPE	ACCEPTABLE LE 07.10.25
.95	.030	.958	✓		CALIPER	
.25	.030	.253	✓		CALIPER	

Measured by: Wk	Audited by: E	Prototype Approval: Wk
Date: 07.10.25	Date: 07/10/25	Date: 07.10.25

Rev	Date	Change	Revised by	Approved
		New Issue		